

Work Order ID 63465

November 2, 2010 12:56:37 PM



Page 1

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 11/02/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CY Date: 10/11/02 Tooling:

Date:

Run Start



QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2445/D350-588	Rev D/D
----------------	---------

Pto →

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

8 n/10/19

JF for CL 11/01/17

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 12854
Description: D2445 Baggage Door
Supplier: Delastek
Ship to Delastek (1) D0588-041 label
Certification of Conformity and process sheet from Delastek is required.

CY 10/11/03 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-588-041 PAR #: _____ Fault Category: Production Intuitive error NCR: Yes No DQA: _____ Date: 11/01/19
 Resolution: Doc. Revised Disposition: _____ QA: N/C Closed Date: 11/02/19

NCR: <u>63465</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/01/19</u>	<u>100</u>	incorrect qty's on - An 960 388 - w/o ask asks - For 8 should be 16. - MS21042 WBS - w/o asks for	<u>[Signature]</u>	- updates qty's to match with 27n on w/o. ADD copy of Bom For Ref.	<u>u</u>	<u>11/02/19</u> <u>[Signature]</u>	<u>[Signature]</u>	<u>S</u> <u>11/01/18</u>
	<u>155</u>	Qty of 8 should be 10 R. who not correctly to up dates. R.C. Other	<u>[Signature]</u>	Customization # 854072 closed	<u>u</u>	<u>now</u> <u>Intuitive</u>		<u>S</u> <u>11/01/19</u>
		missing parts are all ready added in. S w/1/18	<u>[Signature]</u>		<u>u</u>			

NOTE: Date & initial all entries

Work Order ID 63465

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Page 2

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 11/02/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging	Memo	0.00							
Packaging	Ensure Certificate of Conformity & Process Sheet are attached								
130 	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control	Inspect as per Dwg D2445. Audit process sheet.								
140 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble all of the above parts as per Dwg D350-588								

11/01/14 (1)

Submits

(4)

ET 11-01-12 (1)

Work Order ID 63465

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Page 3

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 11/02/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sublot 17

(40)

155

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/1/10 sf

160

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Sublot 18

(40)

Work Order ID 63465

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Page 4

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 11/02/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: B

0.00

R400

11/1/18

SF

10



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/18 MF

11-01-18

Picklist Print

November 2, 2010 12:56:36 PM

Page 1

Work Order ID: 63465

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly



Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP P 04.02.04 Reformat KJ/DS IPP Rev:Q as
per DS19414 DD verified by:EC IPP Rev:R add pick kit DD
10.03.29 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2445P 		Purchased	No			110	Each	0.0000	1	1			
AFT DOOR ASSEMBLY													
AN526C832R9 		Purchased	No			140	Each	149.0000	8	8			
Screw													

B63465 11/1/10

m116419

ST 11-01-17

Location	Loc Qty	Loc Code
ST327	149	
115422	3	
115835	46	
115936	100	

AN960JD10 	NAS1149D0363J	Purchased	No			140	Each	8.0000	2	2			
Washer													

m115622

ST 11-01-17

Location	Loc Qty	Loc Code
ST	6	
107715	6	
ST335	2	
105792	2	

AN960JD8 	NAS1149DN832J	Purchased	No			140	Each	10.0000	8	8			
Washer													

m116513

ST 11-01-17

Location	Loc Qty	Loc Code
ST347	10	
105059	10	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

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Work Order ID: 63465

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

D2143 Manufactured No

140 Each

10.0000

1

1



Hinge Bracket

864308



BT 11-01-17

Location

Loc Qty

Loc Code

ST198

10

55323

10

D2144 Manufactured No

140 Each

35.0000

1

1



Hinge Bracket



BT 11-01-17

Location

Loc Qty

Loc Code

ST198

35

55179

35

D2463 Manufactured No

140 f

486.1100

7.25

7.25



Seal



BT 11-01-17

Location

Loc Qty

Loc Code

ST404

486.11

55561

1.68

62597

484.43

* 7.25

(D2463-0870) cut (1) at 87.00"
**** per kit****

D2585 Manufactured No

140 Each

50.0000

2

2



Mounting Channel



BT 11-01-17

864655

Location

Loc Qty

Loc Code

ST018

33

62676

33

ST019

17

59873

17

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Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 63465

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

D2586 Manufactured No

140 Each

52.0000

2 2



Door Latch

B64656



ET 11-01-17

Location

Loc Qty

Loc Code

ST204

52

61655

52

D2621 Manufactured No

140 Each

67.0000

2 2



Latch Plate, 350 Spacepod



ET 11-01-17

Location

Loc Qty

Loc Code

ST021

67

46842

7

56526

60

D2857-1 Manufactured No

140 Each

28.0000

1 1



Hinge Bracket

64435



ET 11-01-17

Location

Loc Qty

Loc Code

ST026

28

56529

5

57924

23

D2857-2 Manufactured No

140 Each

32.0000

1 1



Hinge Bracket



ET 11-01-17

Location

Loc Qty

Loc Code

ST027

32

55020

1

56530

7

57925

24

ET

Picklist Print

November 2, 2010 12:56:37 PM

Work Order ID: 63465

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

140

Each

160.0000

8

8



M116549



ST 11-01-17

Nut

Location

Loc Qty

Loc Code

ST300

160

115835

160

MS21042L3

Purchased

No

140

Each

1,898.000

4

2



ST 11-01-17

Nut

Location

Loc Qty

Loc Code

ST300

1898

114784

898

115835

1000

x2

MS27039-1-15

Purchased

No

140

Each

47.0000

2

2



ST 11-01-17

Screw

Location

Loc Qty

Loc Code

ST292

47

114056

2

114718

45

AN526C1032R7

Purchased

No

155

Each

46.0000

2

2



M116304 11/11/10

Screw

Location

Loc Qty

Loc Code

ST328

46

113064

1

113749

1

114056

44

Picklist Print

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Work Order ID: 63465

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

AN526C832R8

Purchased

No

155

Each

132.0000

8

8



Screw



M116410 11/1/10

Location

Loc Qty

Loc Code

ST327

132

114615

32

114718

100

AN960JD10

NAS1149D0363J

Purchased

No

155

Each

8.0000

2

2



Washer



M115107 11/1/10

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

AN960JD8

NAS1149DN832

Purchased

No

155

Each

10.0000

16

16



Washer



M116513 11/1/10

Location

Loc Qty

Loc Code

ST347

10

105059

10

D2150

Manufactured

No

155

Each

20.0000

2

2



Packer Doubler, Hinge



B64764 11/1/10

Location

Loc Qty

Loc Code

ST007

20

55178

20

November 2, 2010 12:56:37 PM

Shop Packet Print

Page 5

Picklist Print

November 2, 2010 12:56:37 PM

Work Order ID: 63465

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

D2151
Packer Doubler, Hinge

Manufactured No

155 Each

43.0000

2 2
B64310 11/1/10

Location

Loc Qty

Loc Code

ST007

43

55319

5

62246

38

D2153
Door Prop

Manufactured No

155 Each

16.0000

1 1
B64311 11/1/10

Location

Loc Qty

Loc Code

ST272

16

59818

16

D2154
Stud Bracket

Manufactured No

155 Each

6.0000

1 1
11/1/10

Location

Loc Qty

Loc Code

ST007

6

55325

3

62479

3

D2237
Striker Plate

Manufactured No

155 Each

52.0000

2 2
B64426 11/1/10

Location

Loc Qty

Loc Code

ST009

5

60492

5

ST010

47

62212

47

Picklist Print

November 2, 2010 12:56:37 PM

Work Order ID: 63465

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

D2461 Manufactured No

155 f

115.7072 7.25 7.25



Neoprene "D" Seal



B63880 11/1/10

Location

Loc Qty

Loc Code

ST402

115.7072105

39782

6.5

55054

109.207211

→ measure
5/11/11
(D2461-0870) cut (1) at 87.00"
****per kit****

D2589 Manufactured No

155 Each

161.0000



Keys, Key Chain, 350 Hinge



11/1/10

Location

Loc Qty

Loc Code

ST019

161

58194

161

D2690-17

Manufactured No

155 Each

16.0000



Cable



B64986 11/1/10

Location

Loc Qty

Loc Code

ST021

16

62480

16

D2858-1

Manufactured No

155 Each

15.0000



Hinge Bracket



B63695 11/1/10

Location

Loc Qty

Loc Code

ST027

15

56423

9

61522

6

Picklist Print

November 2, 2010 12:56:37 PM

Work Order ID: 63465

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

D2858-2 Manufactured No

155 Each

7.0000



Hinge Bracket



B62020 11/18/10

Location

Loc Qty

Loc Code

ST027

7

56048

1

61523

6

FG-778150-550-ROL Purchased No

155 sf

1,840.750



7781 9oz Glass 50"x125yd



11/18/10

Location

Loc Qty

Loc Code

ST404

1840.75

108932

18

111166

397

113905

1425.75

CUT ONE SQUARE FEET PER KIT

MS20426AD3-4 Purchased No

155 Each

5,984.000



RIVET



12 11/18/10

Location

Loc Qty

Loc Code

ST316

5984

104374

1984

110398

4000

MS20470AD4-5 Purchased No

155 Each

526.0000



Rivet, Universal Head



18 11/18/10

Location

Loc Qty

Loc Code

ST309

461

114761

461

ST319

65

111916

65

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Shop Packet Print

Picklist Print

November 2, 2010 12:56:37 PM

Work Order ID: 63465

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

155

Each

160.0000

10



Nut



11/6/10 11/18/10

Location

Loc Qty

Loc Code

ST300

160

115835

160

MS21042L3

Purchased

No

155

Each

1,898.000

4



Nut



11/1/10 11/18/10

Location

Loc Qty

Loc Code

ST300

1898

114784

898

115835

1000

MS27039-08-11

Purchased

No

155

Each

45.0000

2



Screw



11/2/10 11/18/10

Location

Loc Qty

Loc Code

ST288

45

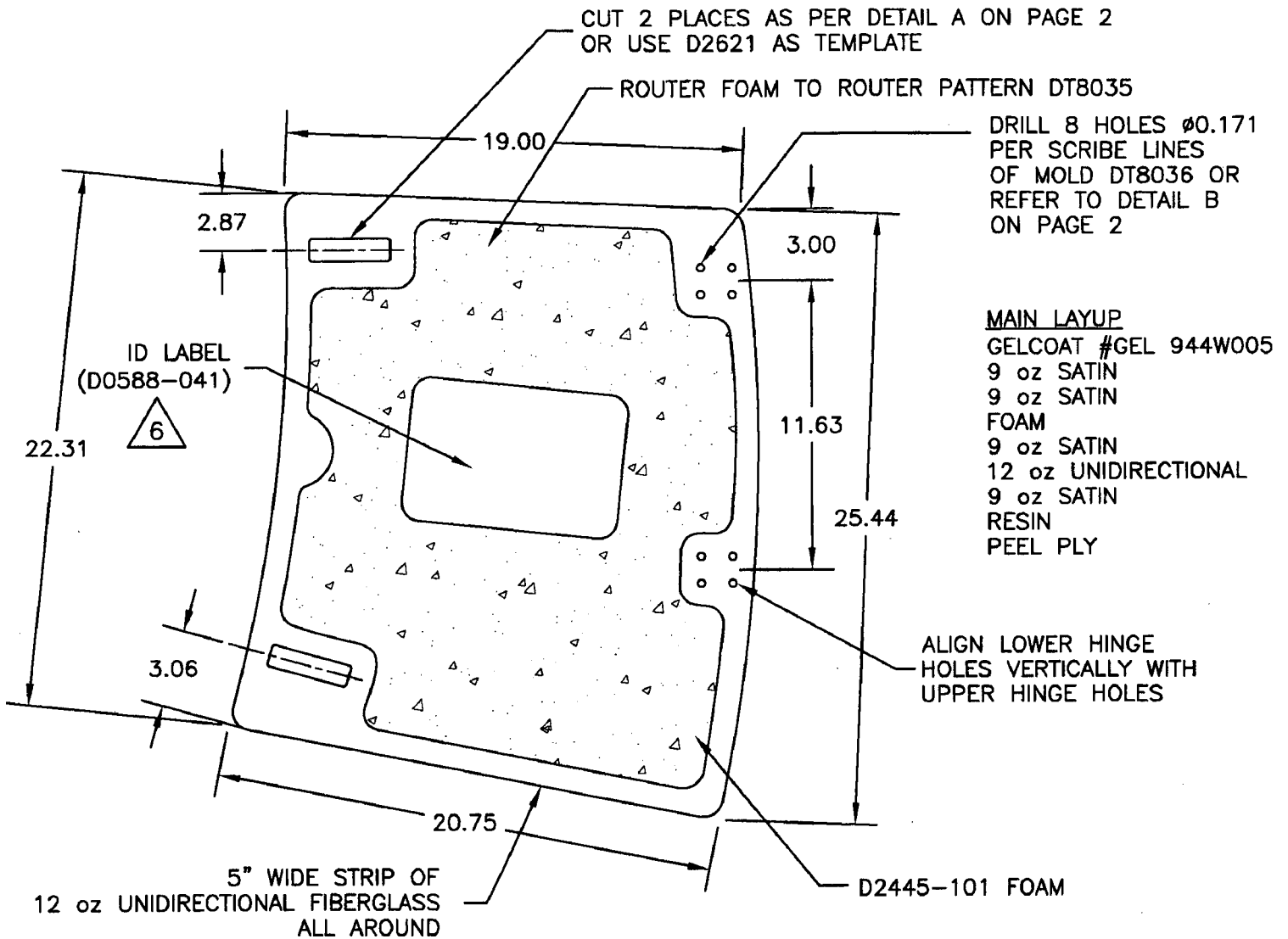
114382

45

2

DART

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09	TITLE AFT BAGGAGE DOOR		SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

RELEASED06.11.13 *[Signature]***NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVINYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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C210/11/02

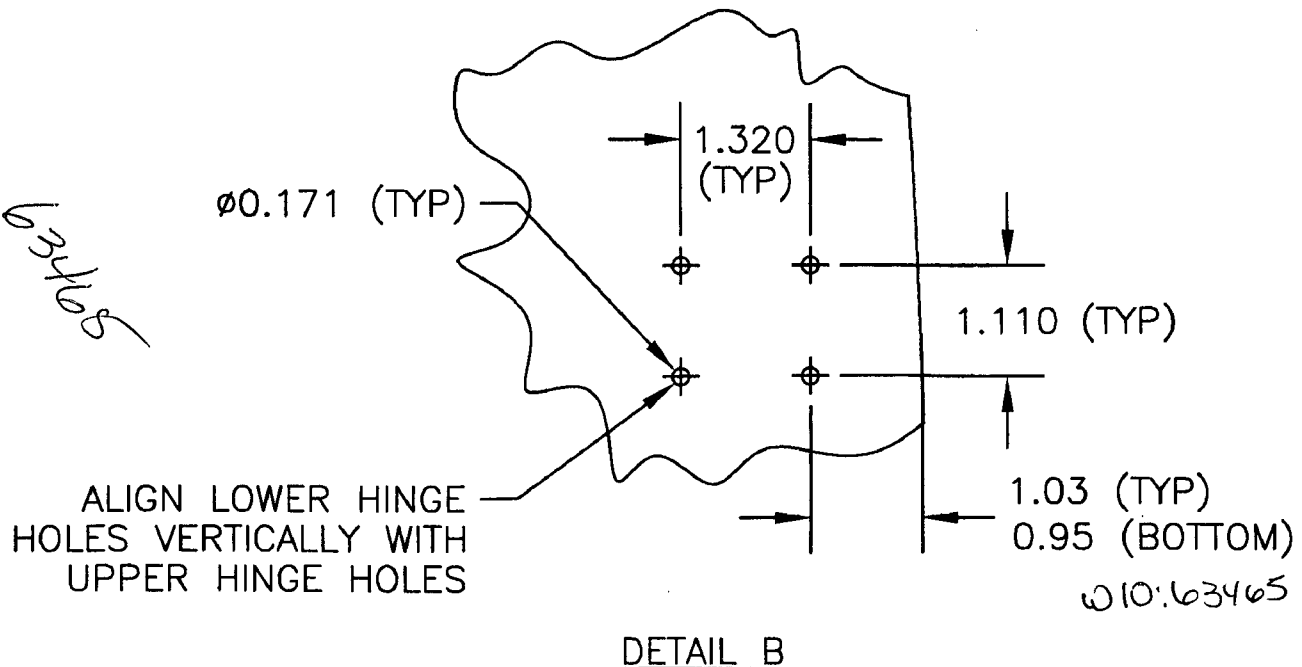
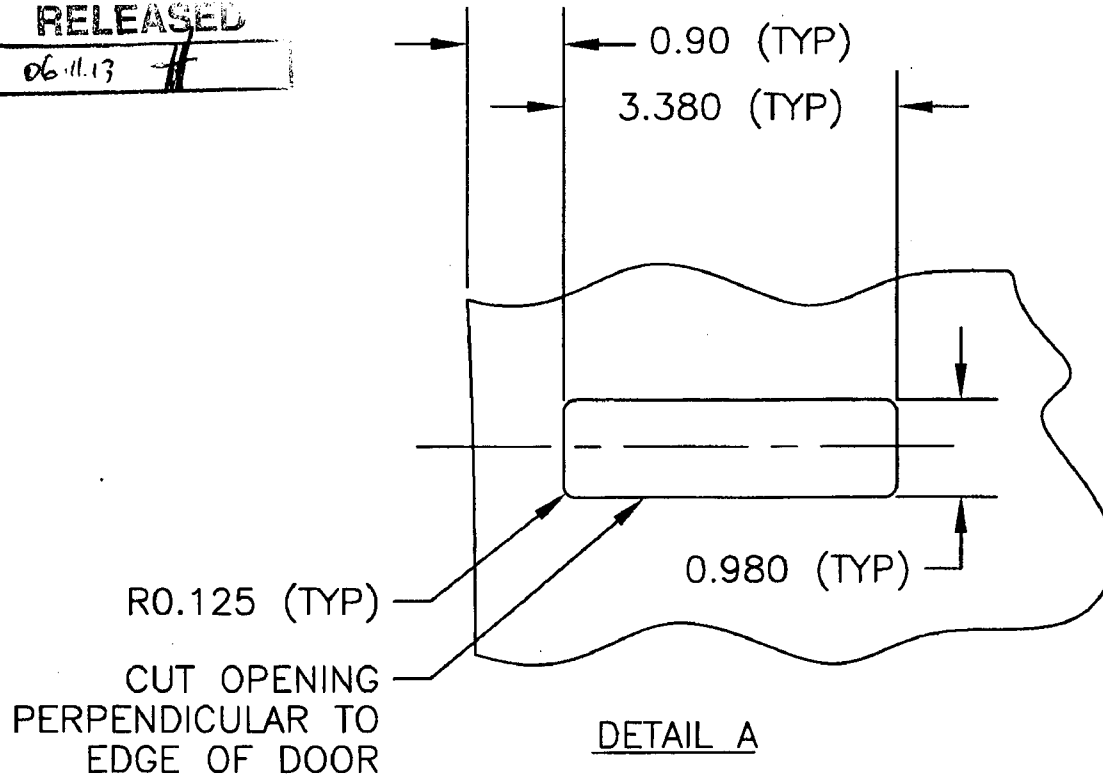
W10! 63465

DART

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09	TITLE AFT BAGGAGE DOOR		SCALE 1:2

RELEASED

06.11.13 *[Signature]*



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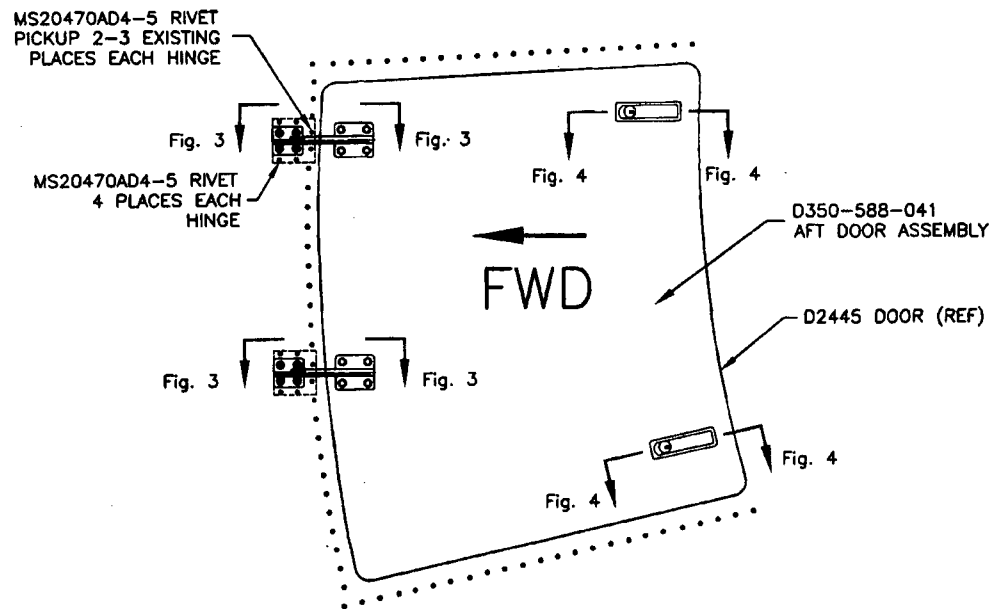


Figure 2: Baggage Door Outside View

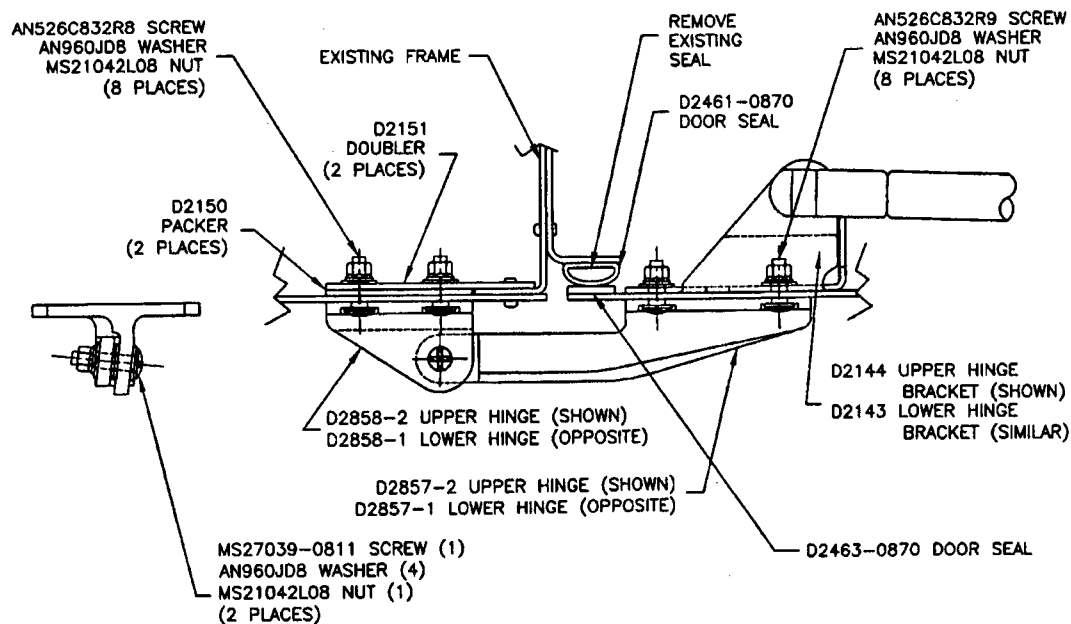
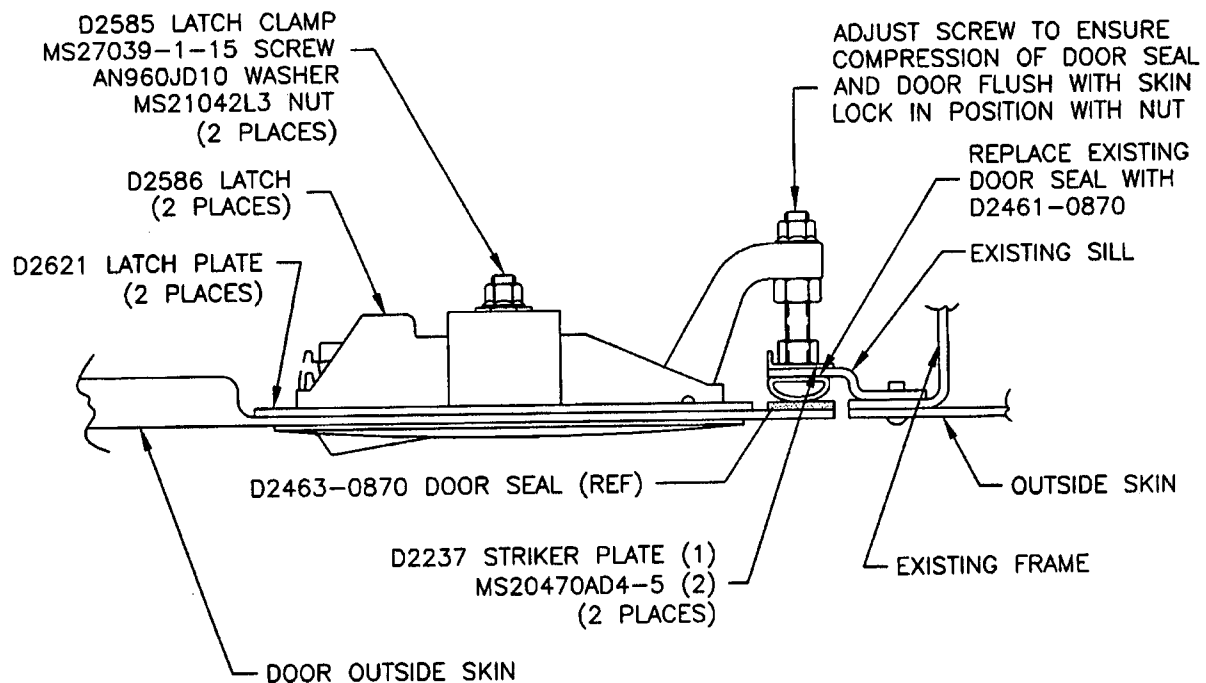


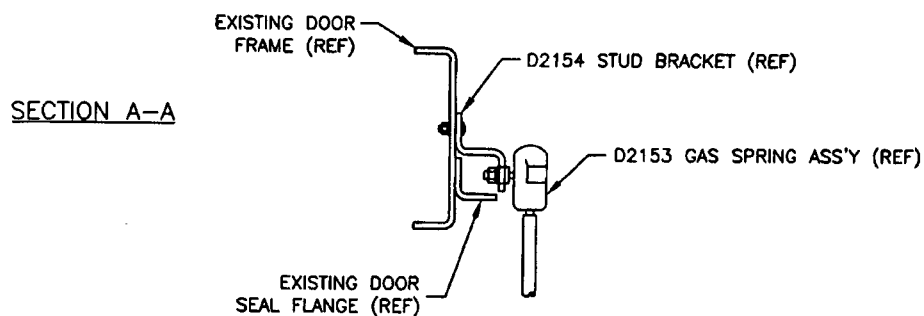
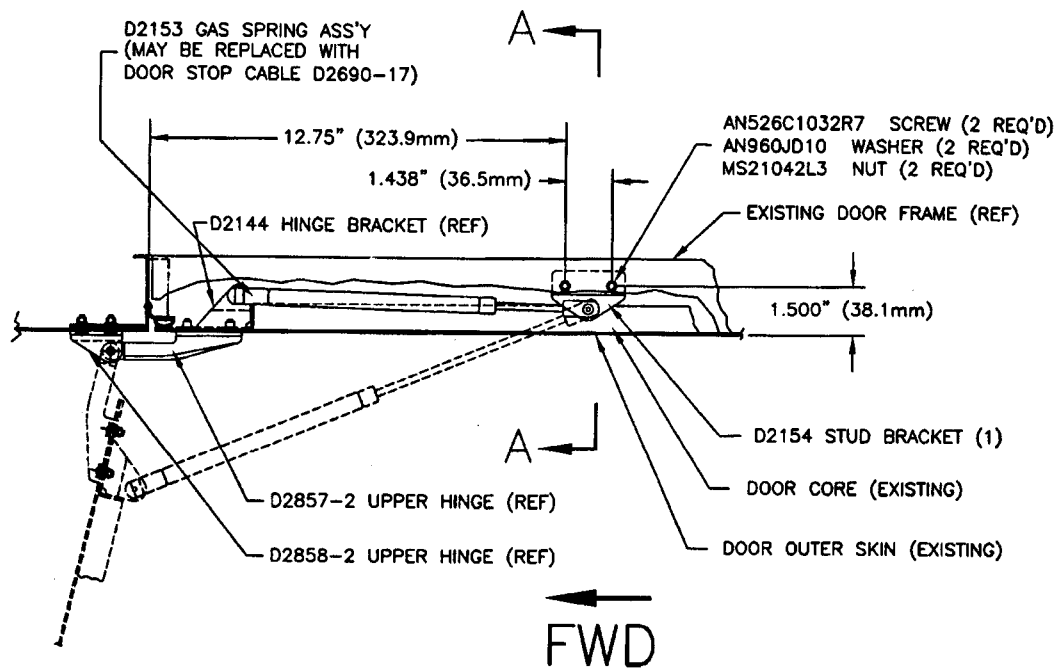
Figure 3: Hinge Detail

W10.63465



W10: 63465

Figure 4: Latch Section



W10:63445

Figure 5: Gas Spring Installation

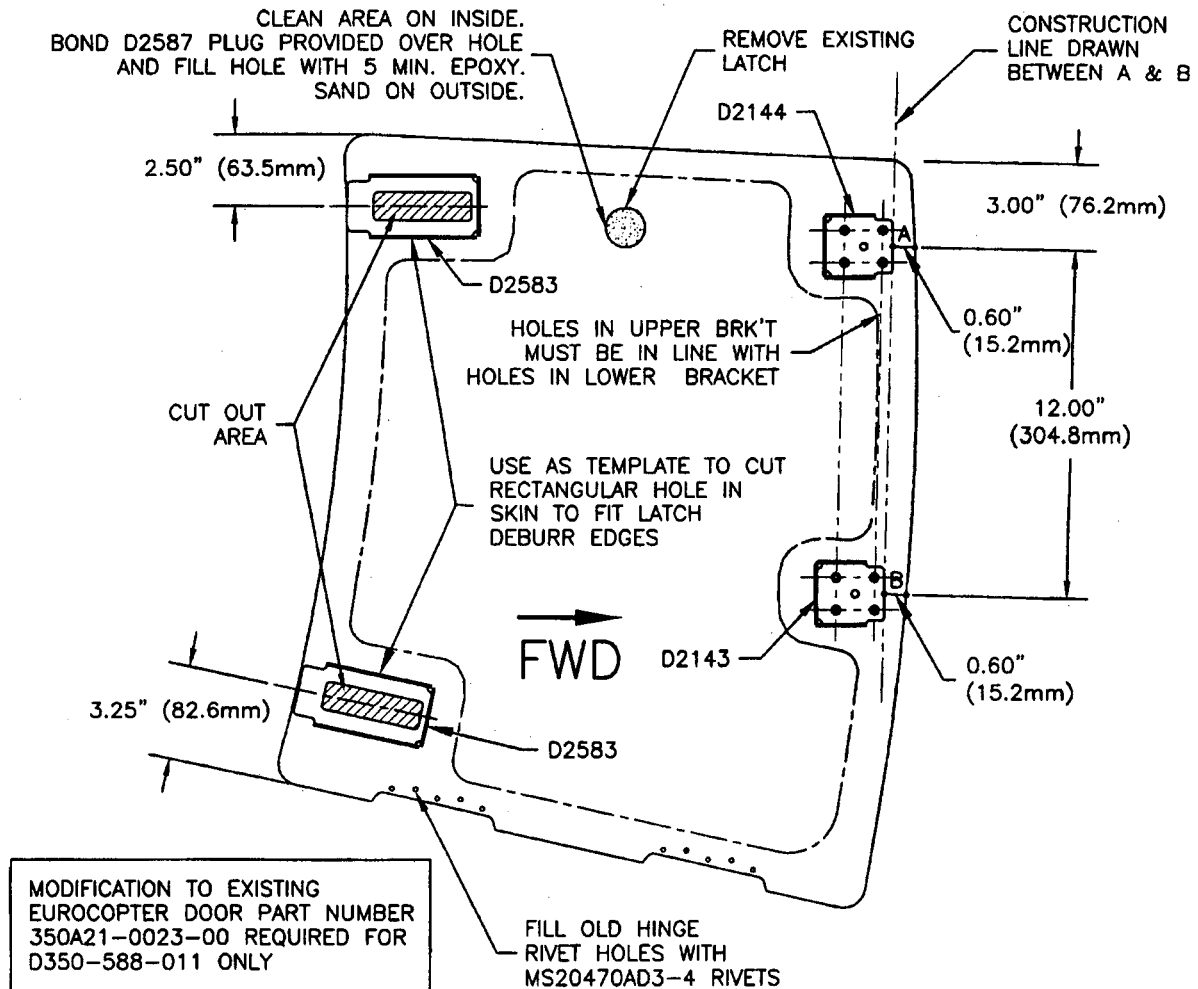
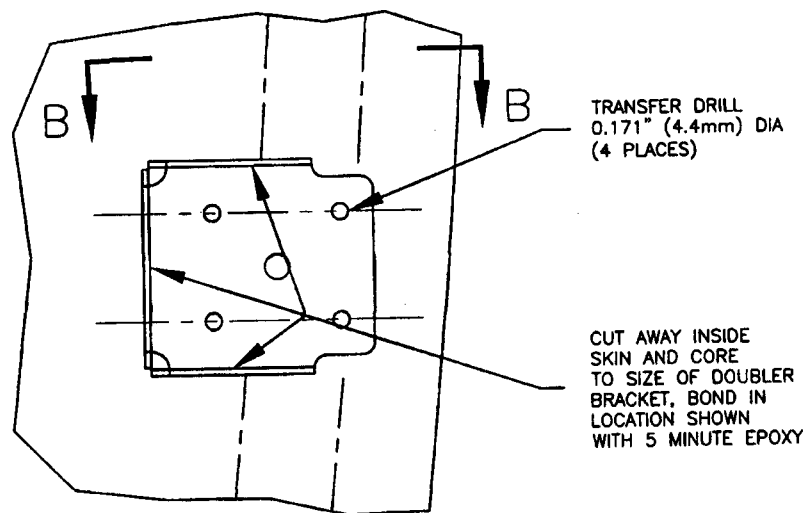
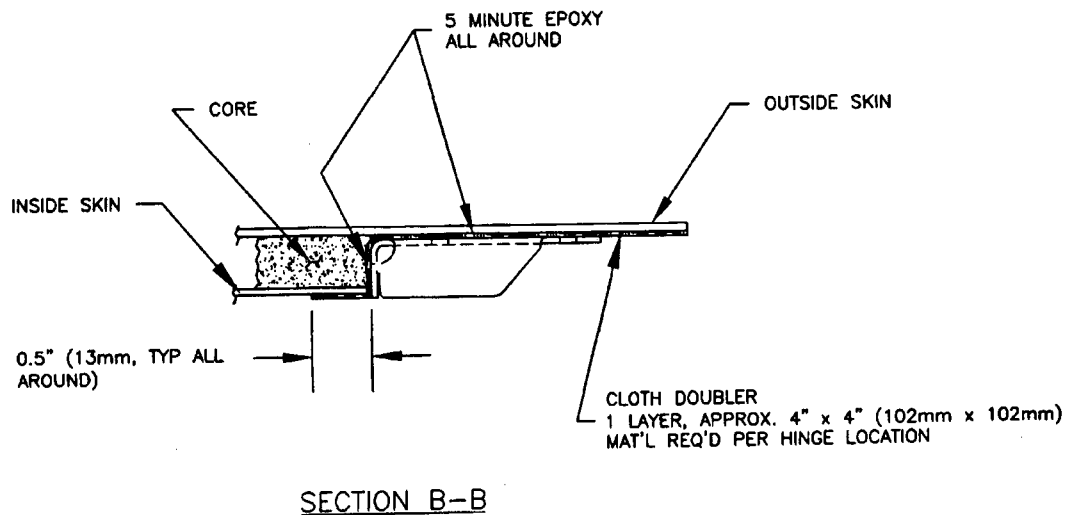


Figure 6: Baggage Door Inside View



WID: 63465

Figure 7: Typical Doubler Bracket Installation

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Revision: **D**

Date: 02.01.17

3.3 **WEIGHT AND BALANCE**

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011 Aft Door Fwd Hinge Modification Kit	1.0 lb 0.45 Kg	-21.0 in -0.53 m	-21.0 in-lb -0.24 m-Kg	+170.0 in +4.32 m	+170.0 in-lb +1.96 m-Kg
D350-588-041* Aft Door Assembly	2.0 lb 0.91 Kg	-21.0 in -0.53 m	-42.0 in-lb -0.48 m-Kg	+170.0 in +4.32 m	+340.0 in-lb +3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

3.4 **PARTS LISTS**

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

w10,63465

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Revision: D

Date: 02.01.17



Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	36614
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
13/01/2011	03/11/2010	15934	Chantal Lavoie	PO12854			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0013	D350-588-041 Aft Baggage Door (D2445) B63465 U de M : Each			
				Drawing N° : D2445 Rév.: D			
				No. série B63465			
				No. lot 30103			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department

AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO12854

Purchase Order Date 11/03/10

PO Print Date 11/03/10

Page Number 1 of 2

Order From :

DELASTEK INC
2699 5E AVENUE, LOCAL C.P 123

VU-DEL003

GRAND-MERE, QC G9T 5K7
CA

Handwritten signature/initials

Contact Name

Vendor Phone 819 533 5788

Vendor Fax 819 533 3494

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
D2445P		AFT DOOR ASSEMBLY	12/03/10 Yes	✓ 1.00 Each	Purolator ground	\$580.0000	\$580.00
		Special Inst: AS PER DWG D 2445 REV. D B63462					
D2445P		AFT DOOR ASSEMBLY	12/03/10 Yes	✓ 1.00 Each	Purolator ground	\$580.0000	\$580.00
		Special Inst: AS ABOVE B63463					
D2445P		AFT DOOR ASSEMBLY	12/10/10 Yes	✓ 1.00 Each	Purolator ground	\$580.0000	\$580.00
		Special Inst: AS ABOVE B63464					
D2445P		AFT DOOR ASSEMBLY	12/10/10 Yes	1.00 Each	Purolator ground	\$580.0000	\$580.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Range Nbr: 1

Change Date: 11/03/10

Date: Jeudi, 2010-11-04 12:55:20
Utilisateur: Pascal Carignan

Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: N° D2445, AFT BAGGAGE DOOR
Numéro Job	: 30103	Numéro Article	: DKC134-0013
Numéro Soumission	: 3959	Numéro Dessin	: D2445
Numéro B.A.	:	Projet Numéro	: DKC134
Cette fois	: 2010-11-04 No. B.V. :	Révision dessin	: D
Prsht Rev.	: NC	Matériel	: Composite
Prem. fois	: - - Type :	Date Dûe	: 2010-11-10 Qté: 1 UdM: UNITE
Job précédente	: 30102		
Écrit par	:		
Vérifié & Approuvé par	:		
Commentaires	: N° de pièce Client: D2445		

Process Sheet Rév.: 00 Création du premier dans DKA à partir de la
Rév.: 10 de DKC

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AC0085 FREKOTE 3,78L 44-NC

Commentaire Qty.: 0.20 UNITE(s)/Unit Total : 0.20 UNITE(s)

2.0 PREP-GENERAL Préparation du matériel



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule N° DT-8036 selon IG 0009

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____

3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Commentaire Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

Gel Coat Blanc N° Gel 944W005

N° de Lot: 1-28605-1

4.0 AMB0286 Catalyst N° DDM-9

Commentaire Qty.: 0.0320 GALLON(s)/Unit Total : 0.0320 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-22176-1

5.0 AC0747 Acetone

Commentaire Qty.: 0.130 KILOGRAMME(s)/Unit Total : 0.130 KILOGRAMME(s)

6.0 PREP-GENERAL Préparation du matériel



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du matériel :

Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à
l'aide de 10% D'acétone.

Date: 23-11-10 Sceau: Temps Début: _____ Temps Fin: _____

Date: Jeudi, 2010-11-04 12:55:20

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 30103

Numéro Article: DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

7.0

GEL COAT

Application du Gel Coat



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'application du Gelcoat selon IG 0019

Date:

23-11-10

Sceau:



Temps Début:

Temps Fin:

8.0

AC0883

Tissu à délaminer Release ply B

Commentaire Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)

9.0

AC0884

Wrighton 5200 Bleu P3

Commentaire Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)

10.0

AC0885

Feutre de drainage N° Airweave N 10

Commentaire Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)

11.0

AC0943

Stretchlon 200 poche à vide Vert

Commentaire Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)

12.0

AMB0214

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentaire Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot:

1-28776-2

13.0

AMB0349

Fiberglass 12 oz Unidirectional

Commentaire Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot:

1-22549-1

14.0

AC0886

Ruban à gommer jaune #: T/AT-200Y

Commentaire Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)

15.0

PREP-GENERAL

Préparation du matériel



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: Jeudi, 2010-11-04 12:55:20

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 30103

Numéro Article: DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date: 9-11-10 Heure Début: _____

Heure Fin: _____

Sceau: _____



16.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0130 GALLON(s)/Unit Total : 0.0130 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-22176-1

17.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-28751-1

18.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantité requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 24-11-10 Heure Début: _____

Heure Fin: _____

Sceau: _____



19.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8036 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 24-11-10 Heure Début: _____

Heure Fin: _____

Sceau: _____



20.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher à l'air ambiant pendant 4 heures minimum.

Date: 24-11-10 Heure Début: _____

Heure Fin: _____













Sceau: _____



Curing début: 10:40 Curing Fin: _____

Date: Jeudi, 2010-11-04 12:55:20
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 30103		Numéro Article: DKC134-0013	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
21.0	AMB0286	Catalyst N° DDM-9	
Commentaire Qty.: 0.0042 GALLON(s)/Unit Total : 0.0042 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-22176-1</u>			
22.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 0.120 KILOGRAMME(s)/Unit Total : 0.120 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-28751-1</u>			
23.0	PREP-GENERAL	Préparation du matériel	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire la préparation de la résine selon les quantités requise, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core.			
Laisser sécher pendant 1 heure.			
Date: <u>22/11/10</u> Heure Début: _____ Heure Fin: _____ Sceau: 			
24.0	AAC1611	Polybond B46F	
Commentaire Qty.: 0.045 KIT(s)/Unit Total : 0.045 KIT(s) Polybond B46F N° de Lot: <u>1-26580-1</u>			
25.0	DKC134-0029	Foam Core N° D2445-101 (Pour AFT Baggage Door)	
Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) Foam Core N° D2445-101 (Pour AFT Baggage Door) N° de Job: <u>26405</u>			
26.0	ASSEMBLAGE	Assemblage mécanique	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Assembler le DKC134-0029 selon IG 0033			
Date: <u>25/11/10</u> Heure Début: _____ Heure Fin: _____ Sceau:  			
27.0	BAGGING	Faire le bagging sur la pièce	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire la poche à vide selon IG 0012			
Laisser sécher à l'air ambiant pendant 2 heures minimum.			
Date: <u>25/11/10</u> Heure Début: _____ Heure Fin: _____ Sceau:  			
Curing Début: <u>1:30</u> Curing Fin: <u>4:00</u>			

Date: Jeudi, 2010-11-04 12:55:20

Utilisateur: Pascal Carignan

Feuille de Procédé

Cient: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 30103

Numéro Article: DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

28.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.1360 GALLON(s)/Unit Total : 0.1360 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-22176-1

29.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-29179-1

30.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 26-11-10

Heure Début: _____

Heure Fin: _____

Sceau: _____



31.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

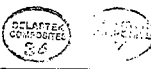
Faire le laminage du dernier pli de 9.7 oz.

Date: 26-11-10

Heure Début: _____

Heure Fin: _____

Sceau: _____



32.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher à l'air ambiant pendant 4 heures minimum.

Date: 26-11-10

Heure Début: _____

Heure Fin: _____

Sceau: _____



Curing Début: 3:10 Curing Fin: 8:00

Date: Jeudi, 2010-11-04 12:55:20
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 30103

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

33.0	DÉMOULAGE	Démoulage de la pièce
------	-----------	-----------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Démouler la pièce selon IG 0018

Date: 29/11/10 Heure Début: Heure Fin: Sceau: 


34.0	TRIMAGE	Trimage
------	---------	---------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2445.

Date: 29/11/10 Heure Début: Heure Fin: Sceau: 

35.0	AAC1605	Label N° D0588-041
------	---------	--------------------

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Label N° D0588-041 N° de Lot: 1-28975-1

36.0	AAC1609	Surface Veil
------	---------	--------------

Commentair Qty.: 0.07 VERGE(s)/Unit Total : 0.07 VERGE(s)
Surface Veil N° de Lot:

37.0	AAC1220	Résine Mia-Poxy 100
------	---------	---------------------

Commentair Qty.: 0.007 GALLON(s)/Unit Total : 0.007 GALLON(s)
Résine Mia-Poxy 100 N° de Lot: 1-25679-1

38.0	AAC1221	Durcisseur 95 Pour Résine Mia-Poxy
------	---------	------------------------------------

Commentair Qty.: 0.007 QUART(s)/Unit Total : 0.007 QUART(s)
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: 1-25679-2


39.0	ASSEMBLAGE	Assemblage mécanique
------	------------	----------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Coller le abel N° D0588-041 selon IG 0111.

Laisser scher pendant 4 heures.

Date: 1/12/10 Heure Début: Heure Fin: Sceau: 

Date: Jeudi, 2010-11-04 12:55:20
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 30103

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
40.0	AAC1390	MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.025 KIT(s)/Unit Total : 0.025 KIT(s)

MASTIC POLYSOFT SIKKENS 3AR591

N° de Lot: 1-26644-1

41.0 AAC1617

Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.02 UNITE(s)/Unit Total : 0.02 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

N° de Lot:


42.0 FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparation de finition s'il y a lieu à l'aide du Sikkens.

Date: 30 nov 10 Heure Début: 11h Heure Fin: 12h Sceau: 

43.0 AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-28050-2

44.0 AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-28382-1


45.0 PRIMER


Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation et l'application du primer selon I.G. 0008

Quantité: 1 Date: 30 nov 10 Sceau: 

Quantité: 1 Date: 3 dec 10 Sceau: 

46.0 INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection selon le dessin N° D2445.

Date: Forcé 10 Heure Début: Heure Fin: Sceau: 

47.0 EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage des pièces selon IG 0057

Date: Jeudi, 2010-11-04 12:55:20
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 30103

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro Article: DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Quantité: 1 Date: 07-Dec-10 Sceau: L. P.

REFERENCE ONLY

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
		D2143	HINGE DOUBLER
		D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
	1	D2857-1	LOWER HINGE BRACKET
	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER -8
4	4	AN960JD10	WASHER -2
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08) -8
4	4	MS21042L3	NUT (or MS21042-3) -2
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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REFERENCE ONLY

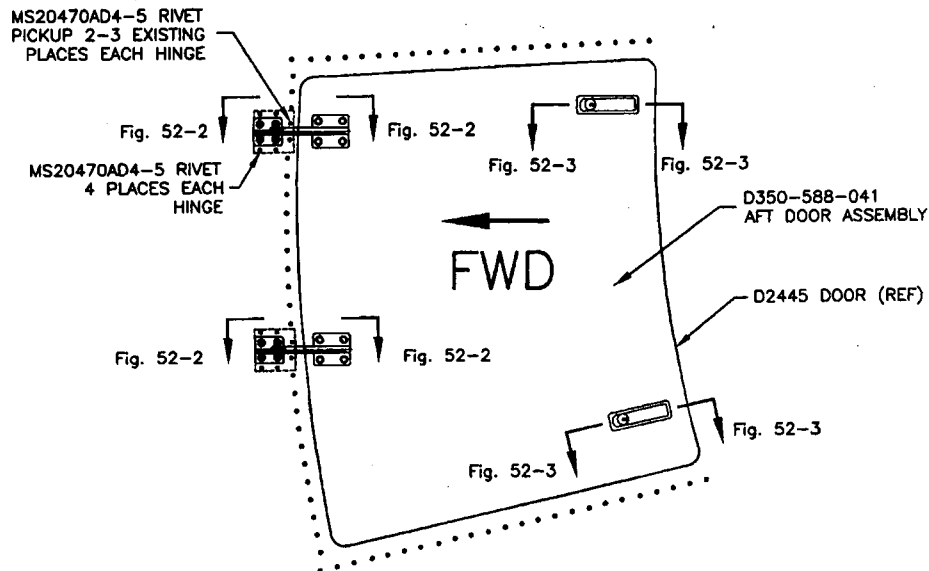


Figure 52-1: Baggage Door Outside View

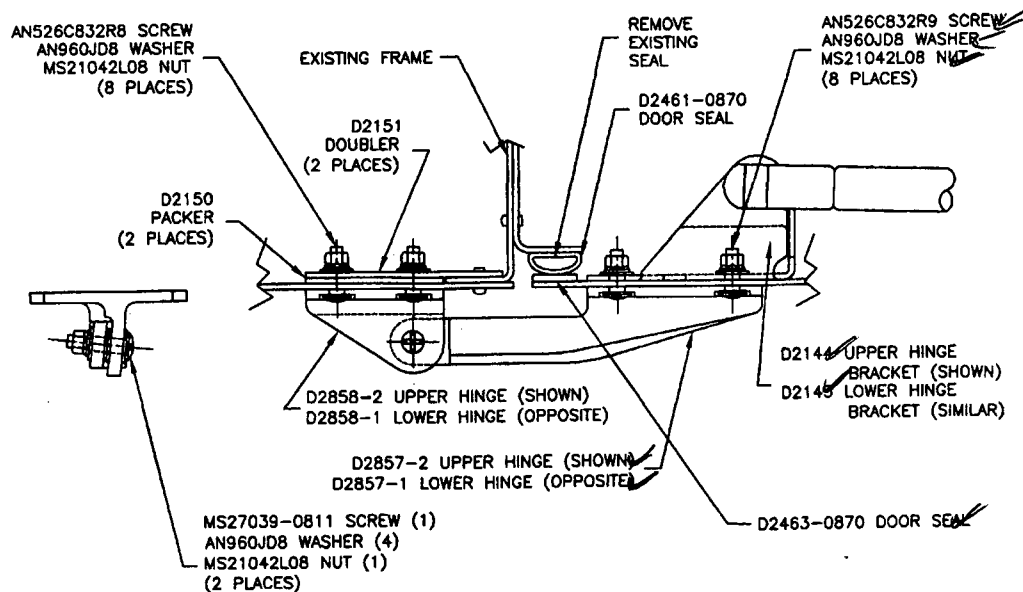


Figure 52-2: Hinge Detail

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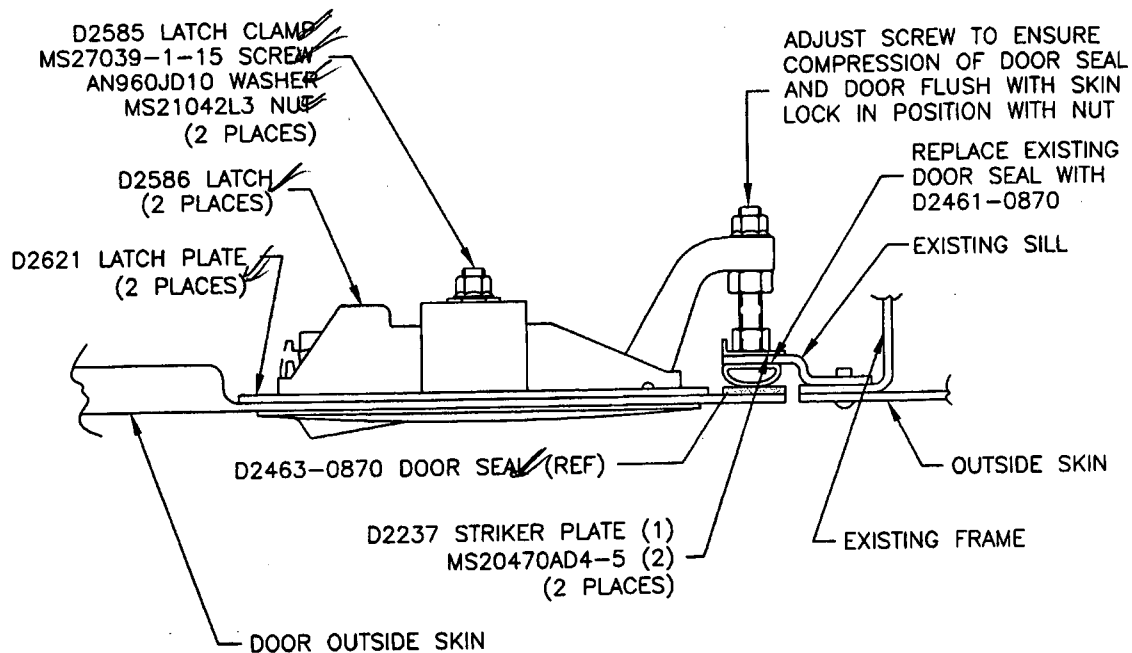


Figure 52-3: Latch Section

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